

Work Order ID 57383

April 6, 2010 9:51:43 AM



Page 1

Item ID: D3574-1

Accept



Setup Start



Revision ID:

Item Name: Cabin Floor Protector

Stop



Start Date: 4/06/10 Start Qty: 4.00



Required Date: 4/09/10 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Handwritten initials

Date: 10-4-06 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3574

Rev B

100



FLOW WATER JET

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3574 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

B 10-4-7

(4)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

B 10-4-7

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

5/10/08

(x4)

Work Order ID 57383

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Page 2

Item ID: D3574-1

Revision ID:

Item Name: Cabin Floor Protector

Start Date: 4/06/10 Start Qty: 4.00

Required Date: 4/09/10 Req'd Qty: 4.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Deburr if necessary.

0.00

0.00

= m-h 10/04/09

(4X)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8 10/04/09

(x4)

150



Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

PN 57382

0.00

0.00

10/4/10 (4)



Work Order ID 57383

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Page 3

Item ID: D3574-1

Revision ID:

Item Name: Cabin Floor Protector

Start Date: 4/06/10 Start Qty: 4.00

Required Date: 4/09/10 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00




QC

Memo

0.00

Quality Control

10/04/12 
MF 10-4-9

Picklist Print

April 6, 2010 9:51:42 AM

Page 1

Work Order ID: 57383

Parent Item: D3574-1

Parent Item Name: Cabin Floor Protector


Comments: IPP Rev :A New Issue 07-01-22 EC

Start Date: 4/06/10

Required Date: 4/09/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	3,040.000	134.4672			
												
GE PLASTICS LEXAN SHEET												



10-4-7

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

MAT

3040

111710

64

112585

224

114032

2752

114032

DART AEROSPACE LTD		Work Order:	57383
Description: Cabin Floor Protector		Part Number:	D3574-1
Inspection Dwg: D3574	Rev: B	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.004	*			
7.37	+/-0.030	7.37	*			
10.75	+/-0.030	10.75	*			
11.00	+/-0.030	11.00	*			
15.25	+/-0.030	15.25	*			
25.87	+/-0.030	25.87	*			
39.75	+/-0.030	39.75	*			
44.75	+/-0.030	44.75	*			
49.11	+/-0.030	49.11	*			
51.11	+/-0.030	51.11	*			
53.51	+/-0.030	53.51	*			
63.50	+/-0.030	63.50	*			
65.25	+/-0.030	65.25	*			
10.75	+/-0.030	10.75	*			
11.06	+/-0.030	11.06	*			
14.75	+/-0.030	14.75	*			
25.50	+/-0.030	25.50	*			
25.75	+/-0.030	25.75	*			
26.00	+/-0.030	26.00	*			
32.87	+/-0.030	32.87	*			
38.81	+/-0.030	38.81	*			
44.75	+/-0.030	44.75	*			
45.00	+/-0.030	45.00	*			
48.25	+/-0.030	48.25	*			
58.38	+/-0.030	58.38	*			
61.25	+/-0.030	61.25	*			
64.13	+/-0.030	64.13	*			
64.63	+/-0.030	64.63	*			
66.50	+/-0.030	66.50	*			
7.50	+/-0.030	7.50	*			
9.50	+/-0.030	9.50	*			
10.38	+/-0.030	10.38	*			
10.88	+/-0.030	10.88	*			
14.50	+/-0.030	14.50	*			

DART AEROSPACE LTD		Work Order:	57383
Description: Cabin Floor Protector		Part Number:	D3574-1
Inspection Dwg: D3574	Rev: B	Page 2 of 2	

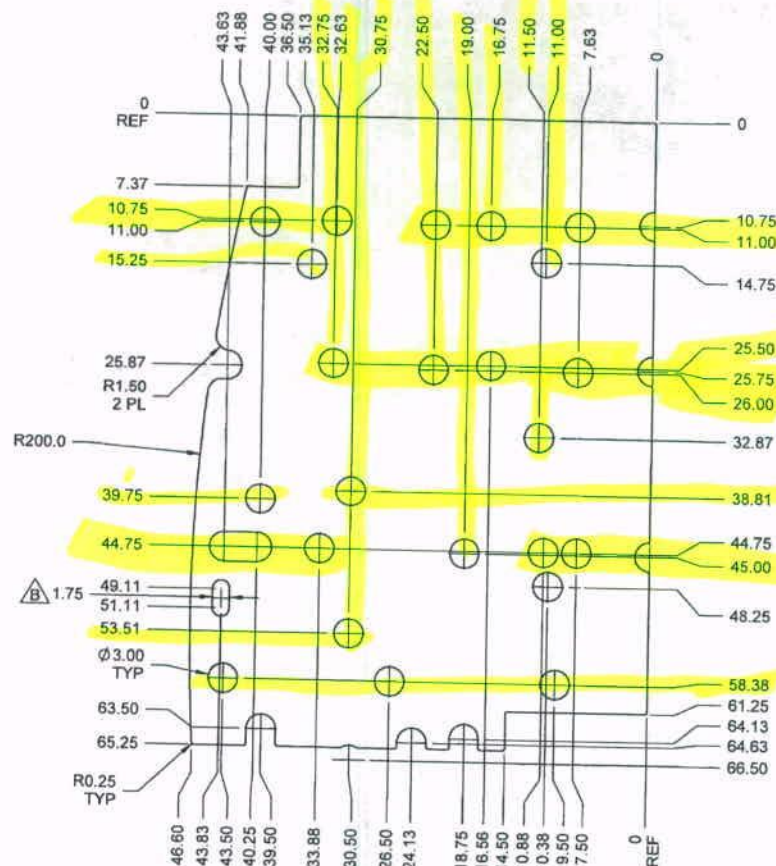
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.56	+/-0.030	16.56				
18.75	+/-0.030	18.75				
24.13	+/-0.030	24.13				
26.50	+/-0.030	26.50				
30.50	+/-0.030	30.50				
33.88	+/-0.030	33.88				
39.50	+/-0.030	39.50				
40.25	+/-0.030	40.25				
43.50	+/-0.030	43.50				
43.83	+/-0.030	43.83				
46.60	+/-0.030	46.60				
7.63	+/-0.030	7.63				
11.00	+/-0.030	11.00				
11.50	+/-0.030	11.50				
16.75	+/-0.030	16.75				
19.00	+/-0.030	19.00				
22.50	+/-0.030	22.50				
30.75	+/-0.030	30.75				
32.63	+/-0.030	32.63				
32.75	+/-0.030	32.75				
35.13	+/-0.030	35.13				
36.50	+/-0.030	36.50				
40.00	+/-0.030	40.00				
41.88	+/-0.030	41.88				
43.63	+/-0.030	43.63				
0.125	+/-0.010	.128				

Measured by: <i>IB</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: 10-4-7	Date: <i>calculus</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ <i>[Signature]</i>	<i>M</i>



D3574-1 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57383

BS10-4-06

RELEASED
01/04/07

B	ADD CUT-OUT TO -1/4" FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5, -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	CB 07.08.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.25	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3574

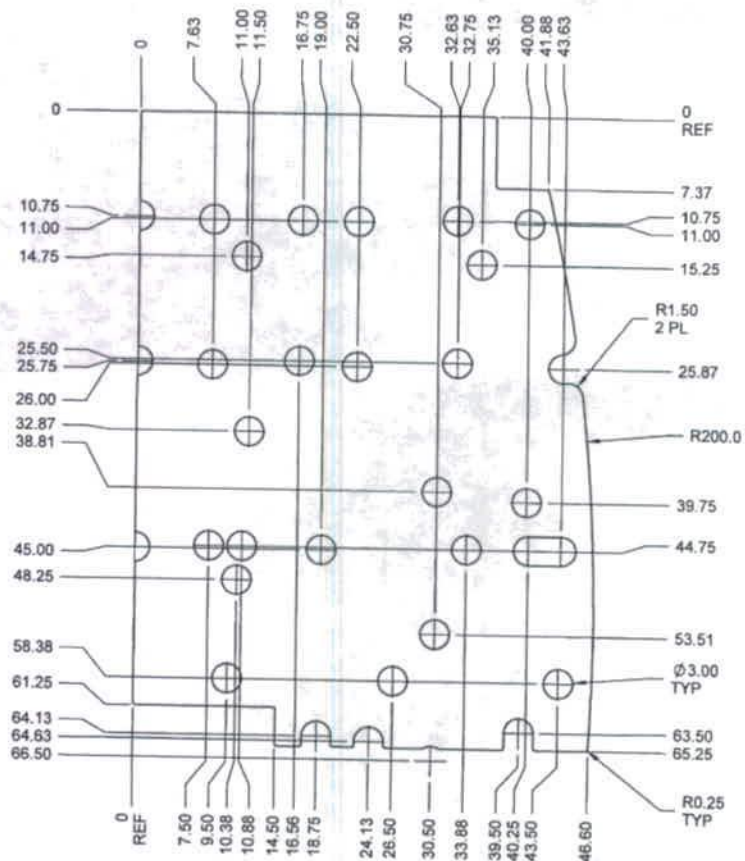
REV. B
SHEET 1 OF 6

TITLE
CABIN FLOOR PROTECTOR

SCALE
NTS

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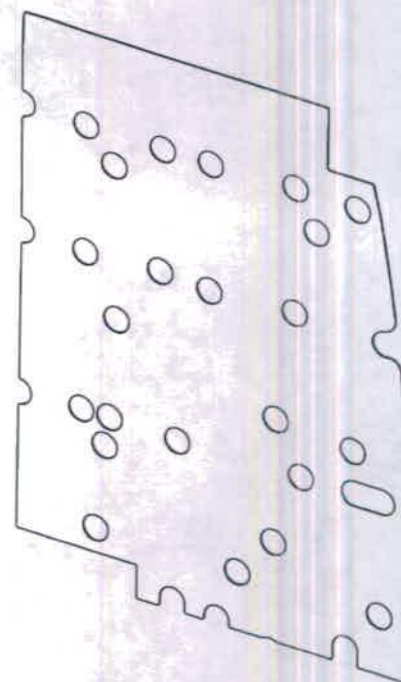
Handwritten text in a cursive script, likely a letter or document. The text is written in dark ink on aged, slightly yellowed paper. The handwriting is fluid and characteristic of the 18th or 19th century. The text is arranged in several lines, with some words appearing to be underlined or emphasized. The overall appearance is that of a historical manuscript or a personal letter.



D3574-2 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-2" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

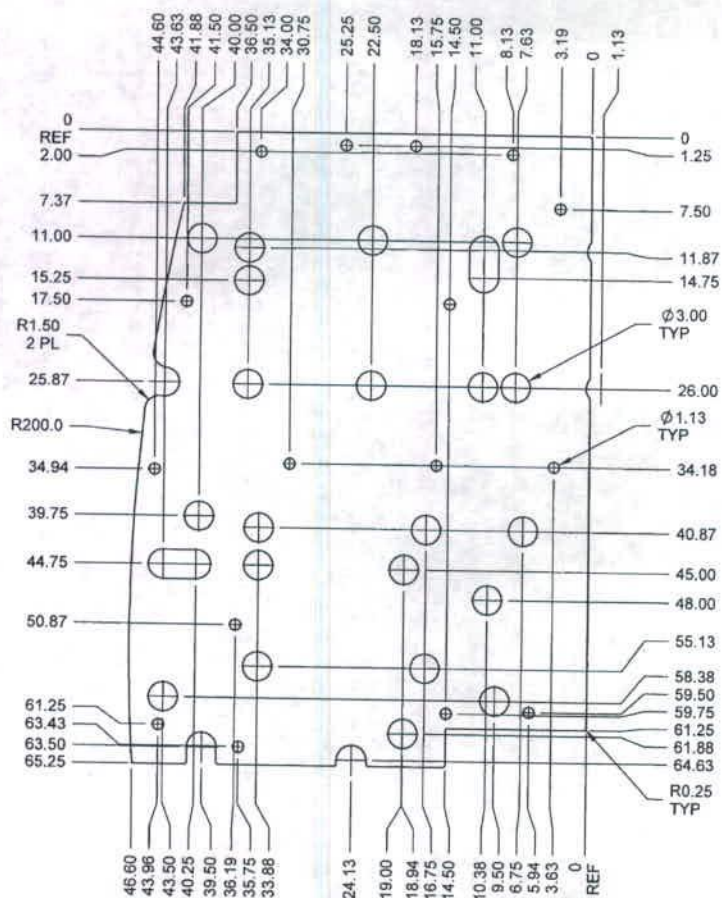


w/o 57383

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07/04/07

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DE APPR.			CABIN FLOOR PROTECTOR	NTS
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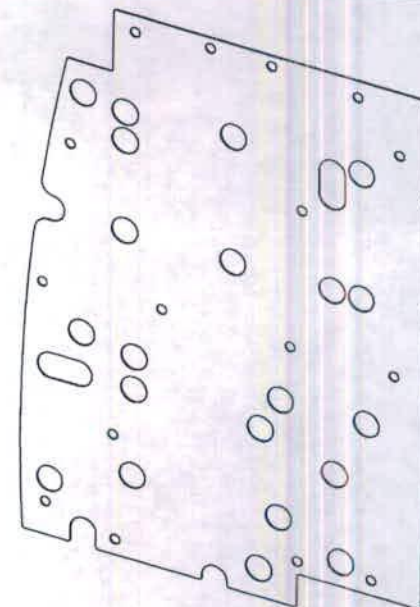




D3574-3 CABIN FLOOR PROTECTOR

NOTES:

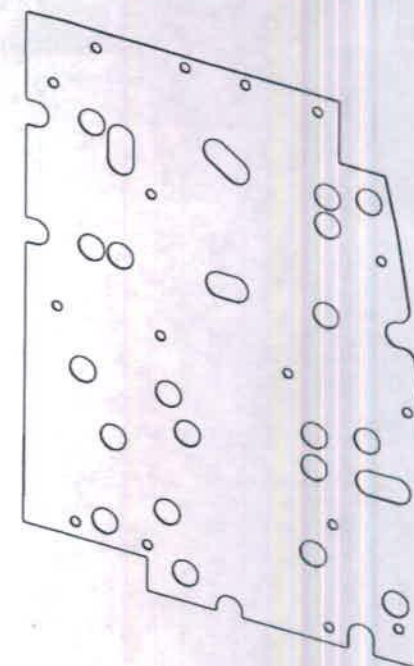
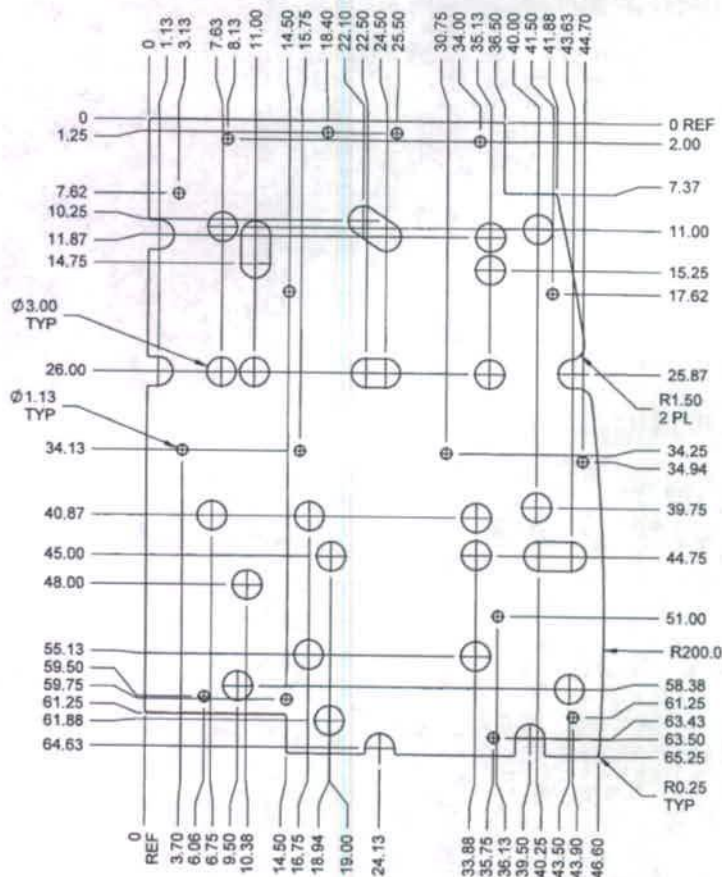
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-3" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.33 lbs
- 8) CHECK PER TEMPLATE DT8962



w/o 57383

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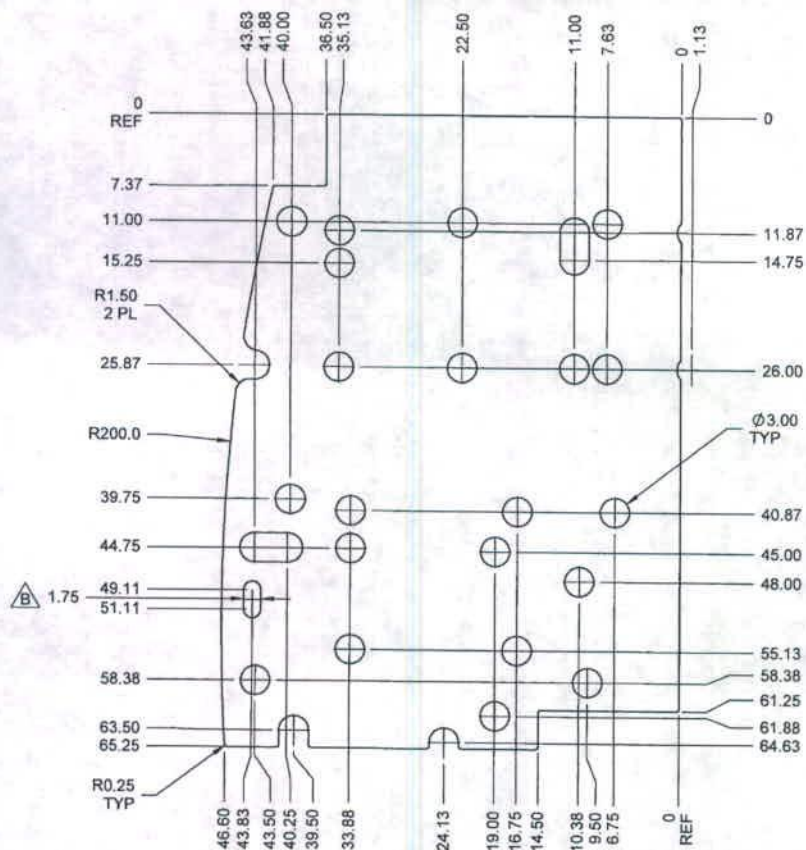
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D3574-4 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-4" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.18 lbs
- 8) CHECK PER TEMPLATE DT8963

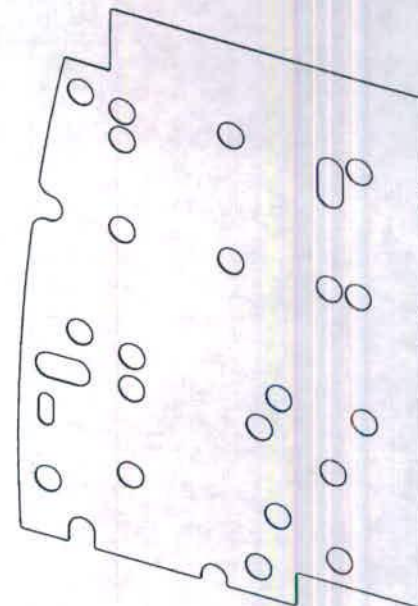
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D3574-5 CABIN FLOOR PROTECTOR

NOTES:

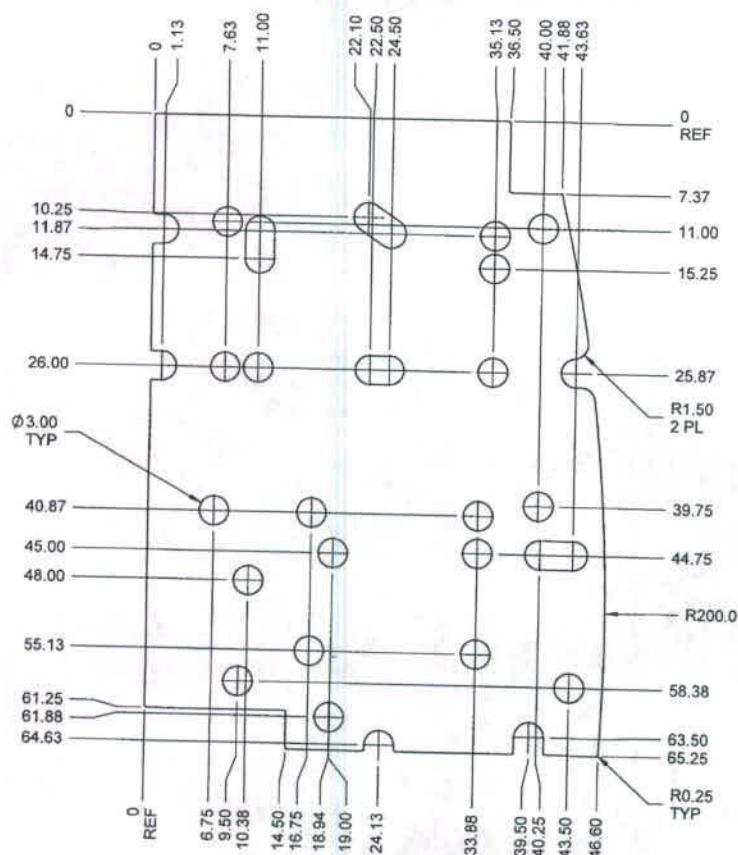
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-5" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.38 lbs
- 8) CHECK PER TEMPLATE DT8964



w/ 57383

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D3574-6 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-6" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.27 lbs
- 8) CHECK PER TEMPLATE DT8965

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
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